



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D412-630-033
Job Sheet 188620



Part No: D412-630-033

Job Qty: 1 ea

Part Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/14/19

Job Tracking No:

Due Date: 2/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV O IPP Rev:A New Issue 06-11-08 JLM IPP rev B ecn 1019, added d2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:EC IPP REV:D 13.06.07 PER CHG004 DD vef:JLM IPP REV:E
16.06.23 AS PER IIN REV.O DD VERF:JLM

Ship Via:

47726

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/5/19	0.00	0.00	Start Up Small Fab-4	6	JAN 24 2019
110	Small Fab	1 pcs		2/5/19	0.00	0.44	Small Fab-6	3-89	36 DAS
120	QC	1 pcs		2/5/19	0.00	0.00	QC5	9-89	38 9-89
130	Packaging	1 pcs		2/5/19	0.00	0.00	Packaging1-4	9-89	69 DAS
140	QC	1 pcs		2/5/19	0.00	0.00	QC4	9-89	69 DAS
145	DC	1 pcs		2/5/19	0.00	0.00	DC	9-89	69 DAS
150	Packaging	1 pcs		2/5/19	0.00	0.00	Packaging3-2	9-89	69 DAS
160	QC21-FG	1 Ea		2/5/19	0.00	0.00	QC21	9-89	69 DAS

Part Op 110 - Assemble as per dwg D412-630 p.14 Coat all hardware with LPS3 rust inhibitor A/R LPS3 batch: ?

Descriptions: COAT exposed HARDWARE WITH LPS PROCYON . A/R LPS PROCYON BATCH: 133690

145 - Photocopy bluefile & create labels per PPP D412-630-033 CHG005

150 - Identify and pack for shipping as per PPP D412-630-033

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN310C8	Nut	2 Ea (2 ea)	90-Start up Operation	5006249
AN3C21A	Bolt	1 Ea (1 ea)	90-Start up Operation	502649
AN8C16	Bolt	2 Ea (2 ea)	90-Start up Operation	FM137706
D2012-107	Clevis	1 pcs (1 ea)	90-Start up Operation	5040916-2
D2803-041	Bracket Assembly	1 pcs (1 ea)	90-Start up Operation	FM148421
D2804-041	Bracket Assembly	1 pcs (1 ea)	90-Start up Operation	5044593
D2807-041	Prop Assembly	2 Ea (2 ea)	90-Start up Operation	5141816
D2813	Washer	2 pcs (2 ea)	90-Start up Operation	5041174
D3395-1	Bushing	4 pcs (4 ea)	90-Start up Operation	5041201
D3562-041	Step Weldment	1 pcs (1 ea)	90-Start up Operation	146612
D3672-15	Phenolic Washer	5 pcs (5 ea)	90-Start up Operation	5042894
D3672-19	Phenolic Washer	4 pcs (4 ea)	90-Start up Operation	FM148075
D3672-7	Washer, Phenolic	4 pcs (4 ea)	90-Start up Operation	5131568
MS21043-3	Nut	4 Ea (4 ea)	90-Start up Operation	5143711
MS24665-302	Cotter Pin	2 Ea (2 ea)	90-Start up Operation	FM135672-1
MS24693-C280	Screw	2 Ea (2 ea)	90-Start up Operation	FM137597
MS24693-C285	Screw	1 Ea (1 ea)	90-Start up Operation	FM135704-30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

AN44C7A	Eyebolt	1 Ea (1 ea)	130-Packaging
AN4C10A	Bolt	1 Ea (1 ea)	130-Packaging
AN4C15A	Bolt	2 Ea (2 ea)	130-Packaging
AN4C6A	Bolt	1 Ea (1 ea)	130-Packaging
AN5C15A	Bolt	2 Ea (2 ea)	130-Packaging
D2806-1	Bushing	2 pcs (2 ea)	130-Packaging
D2806-3	Bushing	2 pcs (2 ea)	130-Packaging
D2810-5	Strut	1 pcs (1 ea)	130-Packaging
D3396-1	Spacer	2 pcs (2 ea)	130-Packaging
D3672-17	Phenolic Washer	7 pcs (7 ea)	130-Packaging
D3672-5	Washer, Phenolic	7 pcs (7 ea)	130-Packaging
MS21043-4	Nut	4 Ea (4 ea)	130-Packaging
MS21043-5	Nut	3 Ea (3 ea)	130-Packaging

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN310C8	2	29	0
	AN3C21A	1	23	0
	AN8C16	2	15	0
	D2012-107	1	25	0
	D2803-041	1	2	0
	D2804-041	1	4	0
	D2807-041	2	8	0
	D2813	2	18	0
	D3395-1	4	46	0
	D3562-041	1	0	0
	D3672-15	5	544	0
	D3672-19	4	172	0
	D3672-7	4	1,115	0
	MS21043-3	4	880	0
	MS24665-302	2	18	0
	MS24693-C280	2	72	0
	MS24693-C285	1	56	0
130-Packaging	AN44C7A	1	18	0
	AN4C10A	1	35	0
	AN4C15A	2	56	0
	AN4C6A	1	399	0
	AN5C15A	2	63	0
	D2806-1	2	3	0
	D2806-3	2	11	0
	D2810-5	1	7	0
	D3396-1	2	33	0
	D3672-17	7	73	0
	D3672-5	7	535	0
	MS21043-4	4	679	0
	MS21043-5	3	140	0

Part Specifications

Specifications could not be found.

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev I



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IPP rev :C 11.01.06 added route seq ID DD vef:EC IPP REV:D 13.06.07 PER CHG004 DD vef:JLM IPP REV:E
16.06.23 AS PER IIN REV.O DD VERF:JLM

Ship Via:

7741

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/25/19	2/5/19	0.00	0.00	Start Up Small Fab-4		SAN 24 2019
110	Small Fab	1 pcs		2/5/19	0.00	0.44	Small Fab-6		
120	QC	1 pcs		2/5/19	0.00	0.00	QC5		
130	Packaging	1 pcs		2/5/19	0.00	0.00	Packaging1-4		
140	QC	1 pcs		2/5/19	0.00	0.00	QC4		
145	DC	1 pcs		2/5/19	0.00	0.00	DC		
150	Packaging	1 pcs		2/5/19	0.00	0.00	Packaging3-2		
160	QC21-FG	1 Ea		2/5/19	0.00	0.00	QC21		

Part Op 110 - Assemble as per dwg D412-630 p.14 Coat all hardware with LPS3 rust inhibitor A/R LPS3 batch: _____

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145 - Photocopy bluefile & create labels per PPP D412-630-033 CHG005

150 - Identify and pack for shipping as per PPP D412-630-033

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN310C8	Nut	2 Ea (2 ea)	90-Start up Operation	
AN3C21A	Bolt	1 Ea (1 ea)	90-Start up Operation	
AN8C16	Bolt	2 Ea (2 ea)	90-Start up Operation	
D2012-107	Clevis	1 pcs (1 ea)	90-Start up Operation	
D2803-041	Bracket Assembly	1 pcs (1 ea)	90-Start up Operation	
D2804-041	Bracket Assembly	1 pcs (1 ea)	90-Start up Operation	
D2807-041	Prop Assembly	2 Ea (2 ea)	90-Start up Operation	
D2813	Washer	2 pcs (2 ea)	90-Start up Operation	
D3395-1	Bushing	4 pcs (4 ea)	90-Start up Operation	
D3562-041	Step Weldment	1 pcs (1 ea)	90-Start up Operation	
D3672-15	Phenolic Washer	5 pcs (5 ea)	90-Start up Operation	
D3672-19	Phenolic Washer	4 pcs (4 ea)	90-Start up Operation	
D3672-7	Washer, Phenolic	4 pcs (4 ea)	90-Start up Operation	
MS21043-3	Nut	4 Ea (4 ea)	90-Start up Operation	
MS24665-302	Cotter Pin	2 Ea (2 ea)	90-Start up Operation	
MS24693-C280	Screw	2 Ea (2 ea)	90-Start up Operation	
MS24693-C285	Screw	1 Ea (1 ea)	90-Start up Operation	
AN44C7A	Eyebolt	1 Ea (1 ea)	130-Packaging	5019401
AN4C10A	Bolt	1 Ea (1 ea)	130-Packaging	FM136044-0
AN4C15A	Bolt	2 Ea (2 ea)	130-Packaging	5044216
AN4C6A	Bolt	1 Ea (1 ea)	130-Packaging	5100397
AN5C15A	Bolt	2 Ea (2 ea)	130-Packaging	FM137587-1
D2806-1	Bushing	2 pcs (2 ea)	130-Packaging	510089X1
D2806-3	Bushing	2 pcs (2 ea)	130-Packaging	5146106X1
D2810-5	Strut	1 pcs (1 ea)	130-Packaging	5034003
D3396-1	Spacer	2 pcs (2 ea)	130-Packaging	5153763
D3672-17	Phenolic Washer	7 pcs (7 ea)	130-Packaging	5101542X1
D3672-5	Washer, Phenolic	7 pcs (7 ea)	130-Packaging	5144111
MS21043-4	Nut	4 Ea (4 ea)	130-Packaging	5150856
MS21043-5	Nut	3 Ea (3 ea)	130-Packaging	5150554
				5147739
				5099519

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN310C8	2	29	2
Allocated Container Detail				
	Qty	Container No	Location	Init
	2	S147813	st331	
	AN3C21A	1	23	1
Allocated Container Detail				
	Qty	Container No	Location	Init
	1	S147814	st348	
	AN8C16	2	15	2
Allocated Container Detail				
	Qty	Container No	Location	Init
	2	S147815	st332	
	D2012-107	1	19	1
Allocated Container Detail				
	Qty	Container No	Location	Init
	1	S147816	st001	
	D2803-041	1	2	1

Allocated Container Detail			
Qty	Container No	Location	Init
1	f148426	st472	_____
D2804-041	1	4	1
Allocated Container Detail			
Qty	Container No	Location	Init
1	S147817	st474	_____
D2807-041	2	24	2
Allocated Container Detail			
Qty	Container No	Location	Init
2	S147818	st011	_____
D2813	2	18	2
Allocated Container Detail			
Qty	Container No	Location	Init
2	S147819	st011	_____
D3395-1	4	46	4
Allocated Container Detail			
Qty	Container No	Location	Init
4	S147820	st033	_____
D3562-041	1	4	0
D3672-15	5	544	5
Allocated Container Detail			
Qty	Container No	Location	Init
5	S147821	st047	_____
D3672-19	4	172	4
Allocated Container Detail			
Qty	Container No	Location	Init
4	S147822	st048	_____
D3672-7	4	989	4
Allocated Container Detail			
Qty	Container No	Location	Init
4	S147823	st047	_____
MS21043-3	4	703	4
Allocated Container Detail			
Qty	Container No	Location	Init
4	S147824	st302	_____
MS24665-302	2	18	2
Allocated Container Detail			
Qty	Container No	Location	Init
2	S147825	st288	_____
MS24693-C280	2	72	2
Allocated Container Detail			
Qty	Container No	Location	Init
2	S147826	st287	_____

MS24693-C285

1

56

1

Allocated Container Detail

Qty	Container No	Location	Init
1	S147827	s1287	
130-Packaging			
AN44C7A	1	18	0
AN4C10A	1	35	0
AN4C15A	2	56	0
AN4C6A	1	339	0
AN5C15A	2	63	0
D2806-1	2	23	0
D2806-3	2	31	0
D2810-5	1	19	0
D3396-1	2	33	0
D3672-17	7	73	0
D3672-5	7	535	0
MS21043-4	4	1,136	0
MS21043-5	3	123	0

Part Specifications

Specifications could not be found.

PAGE 1 OF 1

Description: HELI-ACCESS STEP, LH/RH (FOLDING)

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